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TITLE: PROCESS AND APPARATUS FOR FORMING OVERSIZED CIRCULAR PIPE

Amendment B: CLAIM AMENDMENTS

1. (Original) A process for forming oversized circular pipe comprising:
 - affixing an elliptically-shaped forming head onto a spiral pipe forming machine;
 - driving a metal strip along said elliptically-shaped forming head such that said metal strip takes on a shape of said elliptically-shaped forming head;
 - moving said metal strip out of said elliptically-shaped forming head into a spiral pattern such that edges of said metal strip engage with each other so as to form an elliptically-shaped spiral pipe;
 - removing said elliptically-shaped spiral pipe from said spiral pipe forming machine;
 - and
 - forming said elliptically-shaped pipe into a circular pipe.
2. (Original) The process of Claim 1, said elliptically-shaped forming head having a shape that said circular pipe has a diameter of greater than forty-eight inches.
3. (Original) The process of Claim 1, further comprising:
 - placing a frame adjacent to said spiral pipe forming machine; and
 - positioning rollers on said frame so as to rollably contact an exterior surface of said elliptically-shaped spiral pipe.

4. (Original) The process of Claim 1, said step of affixing comprising:
- affixing a cross bar across said elliptically-shaped forming head;
 - securing a beam in a fixed position relative to said cross bar; and
 - connecting said beam to said cross bar.
5. (Original) The process of Claim 1, said step of affixing comprising:
- positioning a portion of said elliptically-shaped forming head of sharpest curvature at a bottom of said elliptically-shaped forming head; and
 - affixing said portion to said spiral pipe forming machine.
6. (Original) The process of Claim 5, said spiral pipe forming machine having a frame portion spaced from said portion of said sharpest curvature, the process further comprising:
- calculating a shape of said elliptically-shaped forming head such that said forming head does not contact and is spaced from said frame portion.
7. (Original) The process of Claim 1, said step of forming said elliptically-shaped spiral pipe into a circular pipe comprising:
- joining an end of said elliptically-shaped spiral pipe onto an end of a section of circular pipe.
8. (Original) The process of Claim 1, further comprising the step of:
- adjusting a diameter of said elliptically-shaped forming head such that said circular pipe is of a desired diameter.
9. (Original) The process of Claim 8, said step of adjusting the diameter comprising:
- forming a first break on one side of said elliptically-shaped forming head;
 - forming a second break on an opposite side of said elliptically-shaped forming head;

placing a first insert element between edges of said elliptically-shaped forming head at said first break; and

placing a second insert between edges of said elliptically-shaped forming head at said second break, each of said first and second inserts having an interior surface flush with an interior surface of said elliptically-shaped forming head at said first and second breaks, respectively.

10. (Original) The process of Claim 9, further comprising:

affixing a first flange at one edge of said first break;

affixing a second flange at another edge of said first break;

forming said first insert element so as to have a third flange extending outwardly therefrom and a second flange extending outwardly therefrom in parallel relationship to said third flange; and

positioning said first insert element between edges of said elliptically-shaped forming head at said first break such that said third flange is juxtaposed against said first flange and such that said fourth flange is juxtaposed against said second flange.

11. (Original) The process of Claim 10, further comprising:

bolting said first flange to said third flange; and

bolting said second flange to said fourth flange.

12. (Original) The process of Claim 1, said circular pipe having a diameter of 100 inches, said elliptically-shaped forming head having a narrow diameter of 85 inches and a wide diameter of 114 inches.

Claims 13-20 (canceled). These claims are canceled by the present amendment.